

# Work Order ID 66334

Thursday, February 10, 2011 10:42:30 AM

Page 1

Item ID: D4016-1

Accept

Revision ID:

Item Name: Hinge Half, Base

Start Date: 2/10/2011 Start Qty: 12.00

Required Date: 2/11/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4016

A

100

Cut blanks as per folio

0.00

Bandsaw

Memo

0.00

Jcaspa Bandsaw

CUT BLANK 1.00" LONG

110

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA869 AND DWG

FOLIO REV: 8/18

DWG REV: 1

DEBURR



Cust Item ID:

Customer:



11-2-11

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 66334

Thursday, February 10, 2011 10:42:30 AM



Page 2

Item ID: D4016-1

Accept



Setup Start



Revision ID:

Item Name: Hinge Half, Base

Stop



Start Date: 2/10/2011 Start Qty: 12.00

Required Date: 2/11/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*11-2-14*

*12*

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

*11/02/15*

*12*

160



Packaging

Packaging

Identify as per dwg & Stock Location: *PAT* 0.00

Memo

0.00

*12/2/16 (12)*

W/O:		WORK ORDER CHANGES					
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# Work Order ID 66334

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Page 3

Item ID: D4016-1

Accept



Setup Start



Revision ID:

Item Name: Hinge Half Base

Stop



Start Date: 2/10/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 11/02/16 MF 11-02-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, February 10, 2011 10:42:28 AM

Page 1

Work Order ID: 66334

Parent Item: D4016-1

Parent Item Name: Hinge Half Base



Start Date: 2/10/2011

Required Date: 2/11/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B  
as per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	10.8140	0.08	0.96			



304 bar 1.00 x 1.00



Location

Loc Qty

Loc Code

MAT54

10.81397768

113290

10.8139777

11.125 HI

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 46334
<b>Description:</b> Hinge Half, Base		<b>Part Number:</b> D4016-1
<b>Inspection Dwg:</b> D4016	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	.877	/		R.02	
0.25	+/-0.030	.245	/			
0.38	+0.030/-0.000	.389	/			
R0.03	+/-0.030	R.010	/			
0.13	+/-0.030	.126	/			
0.88	+/-0.030	.878	/			
Ø0.257	+0.006/-0.001	.256	/			
R0.38	+/-0.030	R.38	/			
0.500	+/-0.030	.500	/			
0.75	+/-0.030	.753	/			

<b>Measured by:</b> [Signature]	<b>Audited by:</b> [Signature]	<b>Preliminary Approval:</b>
<b>Date:</b> 11-2-14	<b>Date:</b> 11/6/15	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ [Signature]	[Signature]

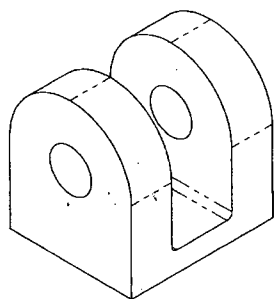
W/O:		WORK ORDER CHANGES					
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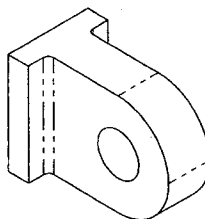
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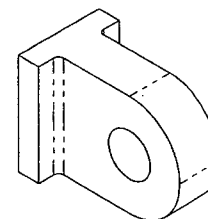
**NOTE:** Date & initial all entries



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

*W/O 66334*

**RELEASED**  
2010-02-16  
*MD*

A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO PART IS TO BE REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

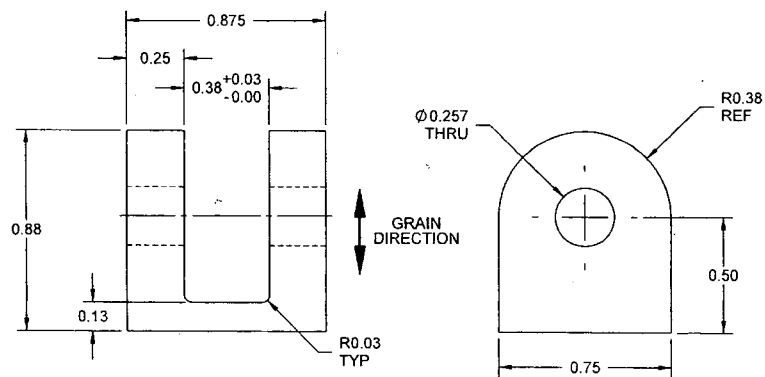
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

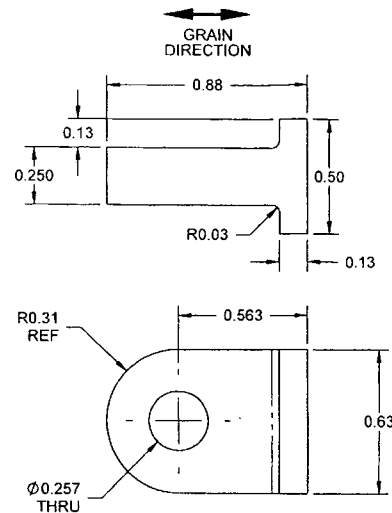
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**D4016-1 HINGE HALF, BASE**



**D4016-3 HINGE HALF, LID**

**D4016-5 HINGE HALF, LIGHT LID**

**NOTES:**

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M304B

-5: 6061-T6/T651/T6511/T62 ALUMINUM BAR,  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

66334

**RELEASED**  
2010-02-16

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BASKET HINGE</b>	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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